

# Work Order ID 61796

Friday, September 03, 2010 1:41:02 PM



Page 1

Item ID: D3936-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Sides

Start Date: 9/3/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: M

Date: 10-9-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3936	A								
100		0.00							
Waterjet	<b>Memo</b>	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3936								
6061.040	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	***grain direction per dwg***								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									

10-9-20

(4)

10-9-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 61796**

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Page 2

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		8/10/12/22		(74)			
121  Small Fab Small Fab	 Memo 1- C'sink holes as per dwg	0.00 0.00		N/A					
130  Brake NC Brake NC	 Memo Bend and make joggle as per Dwg	0.00 0.00		SP 10/09/28		(H)			

W/O:		WORK ORDER CHANGES					
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Page 3

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Stop



Item Name: Sides

Start Date: 9/3/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8.01013



144



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

N/A

see w/061795

146



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

W/A

W/O:		WORK ORDER CHANGES					
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**Work Order ID 61796**

Friday, September 03, 2010 1:41:02 PM



Page 4

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Revision ID:

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Cust Item ID:

Required Date: 9/14/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Packaging

Identify as per dwg & Stock Location: GA

0.00

Memo

0.00

SO 10/10/13

Packaging

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/13  
mf  
10-10-13

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**NOTE:** Date & initial all entries



# Picklist Print

Friday, September 03, 2010 1:41:07 PM

Page 1

Work Order ID: 61796

Parent Item: D3936-1

Parent Item Name: Sides



Start Date: 9/3/2010

Required Date: 9/14/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC  
conversion DD 10.02.08 verified by:JLM  
IPP RevB: add chemical

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040		Purchased	No			100	sf	86.7300	2.75	11.57895			



6061-T6 .040 Sheet



1810-9-20

Location

Loc Qty

Loc Code

MAT21

86.73

113004

86.73

113004

4

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	01794
<b>Description: Sides</b>		<b>Part Number:</b>	D3936-1
<b>Inspection Dwg: D3936 Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.100	✓		V	1302
0.300	+/-0.010	0.306	✓		V	
1.200	+/-0.010	1.200	✓		V	
8.400	+/-0.010	8.403	✓		✓	
1.200	+/-0.010	1.198	✓		✓	
10.100	+/-0.010	10.104	✓		V	HB PROVIS-02
0.300	+/-0.010	0.303	✓		V	
1.200	+/-0.010	1.200	✓		V	
2.100	+/-0.010	2.104	✓		✓	
0.700	+/-0.010	0.701	✓		✓	
4.698	+/-0.010	4.696	✓		V	
9.900	+/-0.010	9.897	✓		V	
1.100	+/-0.010	1.102	✓		V	
18.996	+/-0.010	18.996	✓		T	1301
2.100	+/-0.010	2.103	✓		T	
0.700	+/-0.010	0.700	✓		V	
23.993	+/-0.010	23.993	✓		T	
2.700	+/-0.010	2.700	✓		V	
0.900	+/-0.010	0.900	✓		V	
39.198	+/-0.010	39.198	✓		T	
0.040	+/-0.010	0.040	✓		V	

<b>Measured by:</b>	HB	<b>Audited by:</b>	S	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	10-9-20	<b>Date:</b>	10/09/22	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.21	New Issue	KJ	M

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

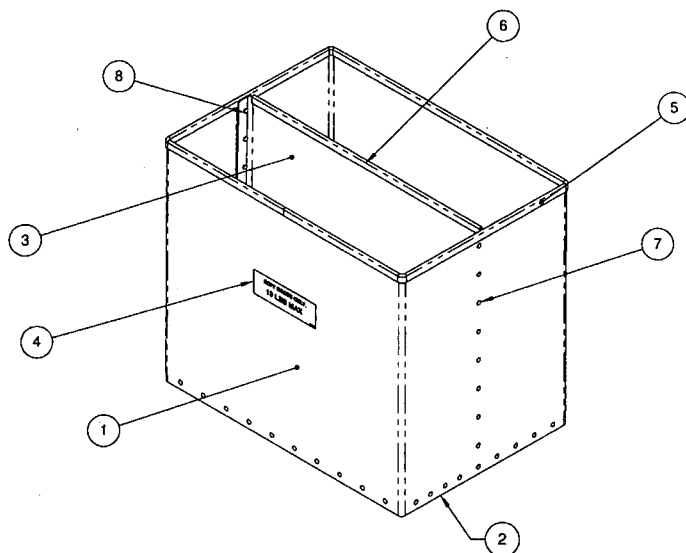
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	1	D3936-1	SIDES
2	1	D3936-3	BOTTOM
3	1	D3936-5	DIVIDER
4	1	D3938-3	PLACARD
5	1	D3941-40	RUBBER CUSHION
6	1	D3941-12	RUBBER CUSHION
7	56	MS20426AD3-4	RIVET
8	8	MS20426AD3-5	RIVET



**D3936-041 MAPBOX ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3936-041" AND B/N USING A WHITE FINE POINT PAINT MARKER
- 7) WEIGHT: 2.54 lbs

**ASSEMBLY INSTRUCTIONS**

1. BEND D3936-1/-3/-5 PARTS PER SHEETS 2-7.
2. POSITION D3936-5 DIVIDER IN PLACE INSIDE THE D3936-1 SIDES AND CLECO IN PLACE.
3. POSITION THE D3936-3 BOTTOM IN PLACE AGAINST THE D3936-5 DIVIDER AND INSIDE THE D3936-1 SIDES.
4. TRANSFER DRILL 10X  $\phi 0.098$  (#40 DRILL) HOLES FROM THE D3936-3 BOTTOM TO THE D3936-5 DIVIDER. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
5. TRANSFER DRILL 38X  $\phi 0.098$  HOLES FROM D3936-1 SIDES TO D3936-3 BOTTOM. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
6. REMOVE ALL CLECOS AND COUNTERSINK 64X EXTERIOR HOLES  $\phi 0.179 \times 100^\circ$ . DEBURR ALL HOLES IN ALL PARTS.
7. REASSEMBLE PARTS USING CLECOS IN EVERY THIRD HOLE TO MAINTAIN ALIGNMENT.
8. RIVET D3936-1 SIDE TO D3936-5 DIVIDER USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
9. RIVET D3936-5 DIVIDER TO D3936-3 BOTTOM USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
10. RIVET D3936-3 BOTTOM TO D3936-1 SIDE USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
11. POWDER COAT ASSEMBLY PER NOTE 2.
12. TEST FIT RUBBER CUSHION TO TOP EDGE OF MAPBOX. TRIM AS REQUIRED FOR PROPER FIT.
13. REMOVE RUBBER CUSHION.
14. APPLY SMALL BEAD OF SILICONE/ADHESIVE TO TOP EDGE OF MAPBOX.
15. SLIDE RUBBER CUSHION OVER EDGE AND PRESS INTO SILICONE/ADHESIVE.
16. WIPE OFF ANY EXCESS SILICONE/ADHESIVE BEFORE IT DRIES/CURES.
17. APPLY D3938-3 PLACARD AS SHOWN.
18. ALLOW SEALANT/ADHESIVE TO CURE/DRY 24 HRS BEFORE SHIPPING PART.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 61794

610-9-00

**RELEASED**  
2009-08-28  
*and*

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>		09.07.08
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>ALS</i>	DRAWING NO. <b>D3936</b>	REV. A	
MFG. APPR.	<i>JS</i>		SHEET 1 OF 7	
APPROVED	<i>JS</i>	TITLE <b>MAPBOX</b>	SCALE	
DE APPR.	<i>JS</i>		NTS	
DATE	09.07.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

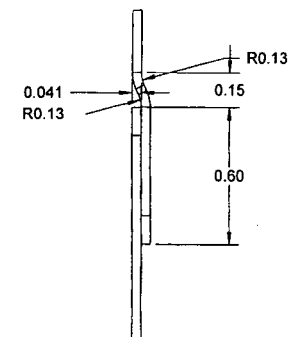
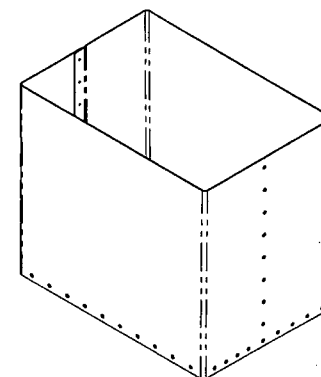
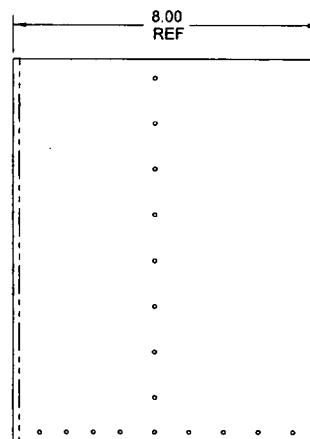
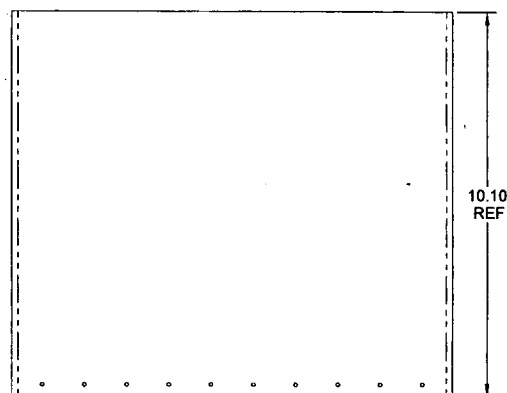
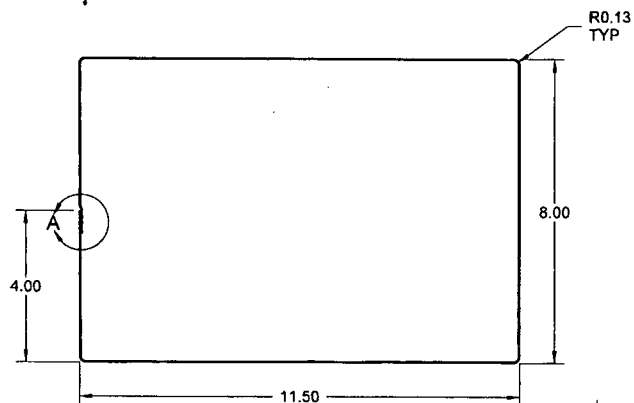
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



DETAIL A  
SCALE 5x

D3936-1 SIDES  
MADE FROM D3936-1F

**RELEASED**  
2009-08-28  
MB

*WLO 41796*

NOTES:

- 1) MATERIAL: MADE FROM D3936-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.54 lbs

DESIGN	<i>JE</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO. <b>D3936</b>	REV. A
MFG. APPR.	<i>RED</i>	SHEET 2 OF 7	
APPROVED	<i>WJH</i>	TITLE <b>MAPBOX</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DATE	09.07.08	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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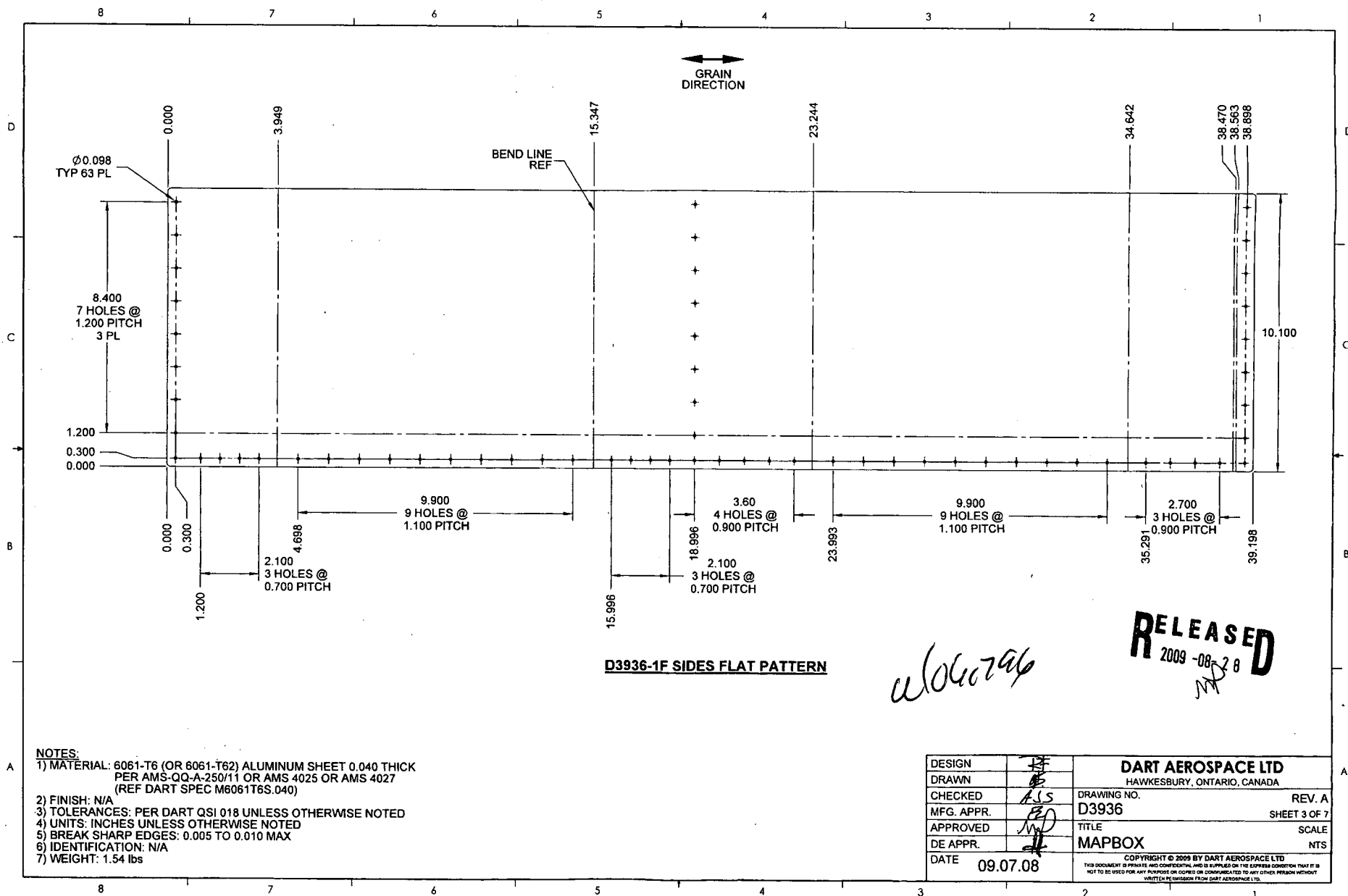
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8 7 6 5 4 3 2 1

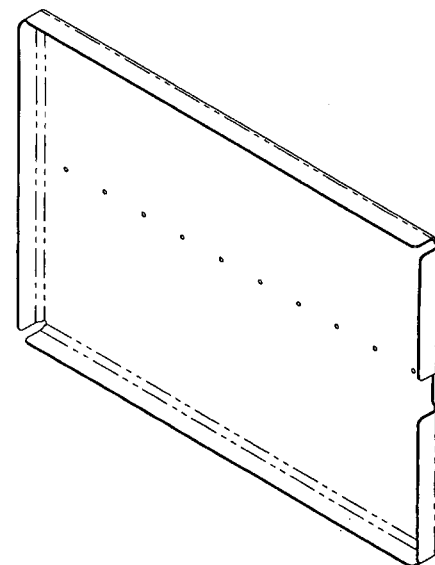
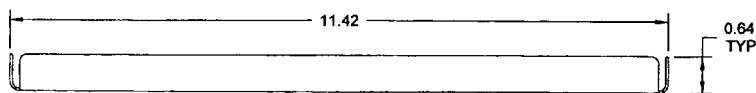
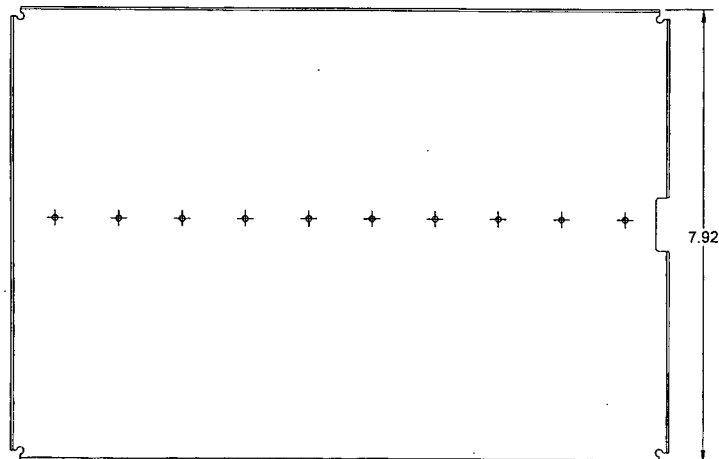
D

C

B

A

C



D

C

B

A

**D3936-3 BOTTOM**  
MADE FROM D3936-3F

*21061295*

**RELEASED**  
2008-08-28  
*MM*

**NOTES:**

- 1) MATERIAL: MADE FROM D3936-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

DESIGN	JS	<b>DART AEROSPACE LTD</b>	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	JS	<b>D3936</b>	SHEET 4 OF 7
APPROVED	MM	TITLE	SCALE
DE APPR.	JS	<b>MAPBOX</b>	NTS
DATE	09.07.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

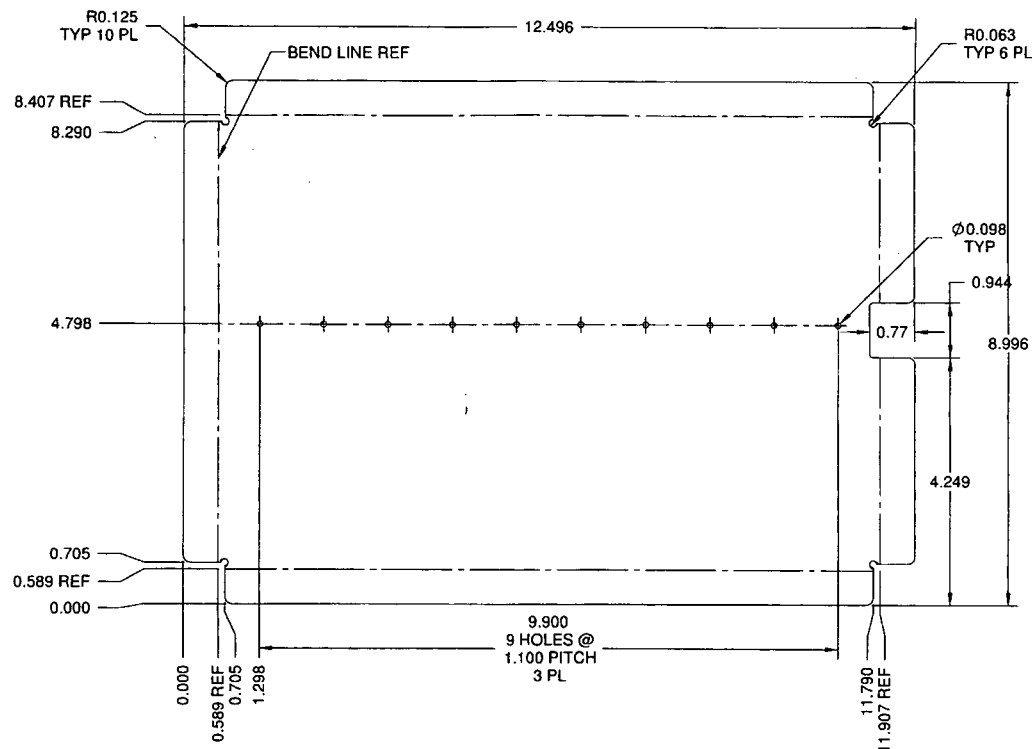
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**D3936-3F BOTTOM FLAT PATTERN**

**RELEASED**  
2009-08-28  
MD

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF DART SPEC M6061T6S.040)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

*w6041296*

DESIGN	<i>DF</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>FE</i>	<b>D3936</b>	SHEET 5 OF 7
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	<b>MAPBOX</b>	NTS
DATE	09.07.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

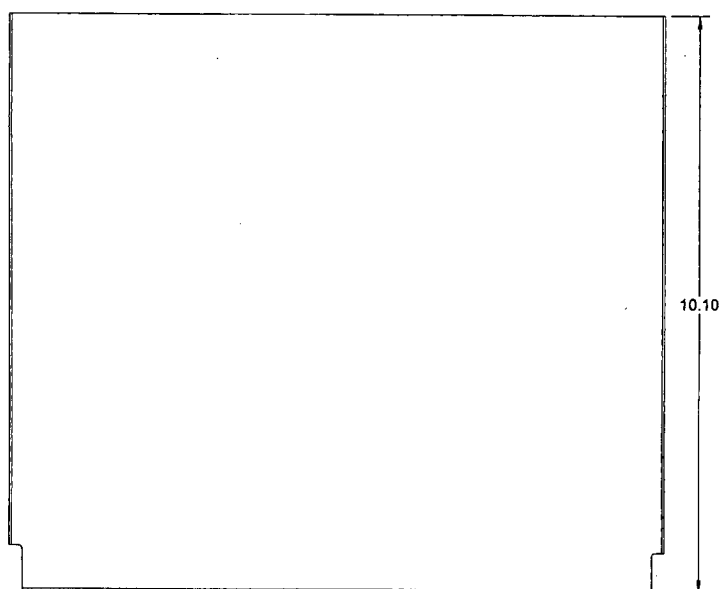
A

D

C

B

A

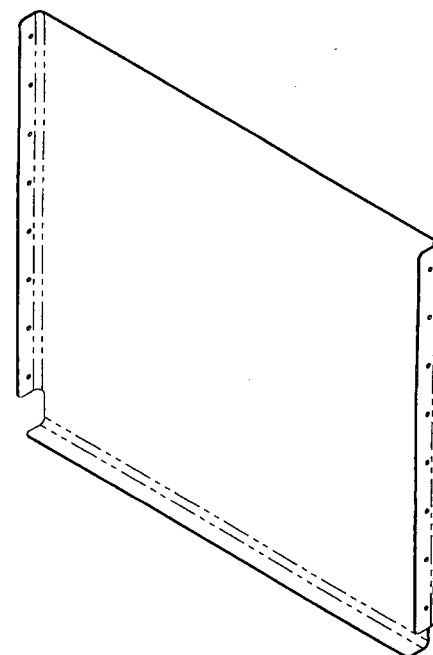


10.10

11.38

0.60  
TYP

R0.13  
TYP



**D3936-5 DIVIDER**  
MADE FROM D3936-5F

**RELEASED**  
2009-08-28

- NOTES:
- 1) MATERIAL: MADE FROM D3936-5F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.50 lbs

*260 GRTY*

DESIGN	<i>260</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>260</i>		
CHECKED	<i>260</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>260</i>	D3936	SHEET 6 OF 7
APPROVED	<i>260</i>	TITLE	SCALE
DE APPR.	<i>260</i>	MAPBOX	NTS
DATE	09.07.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

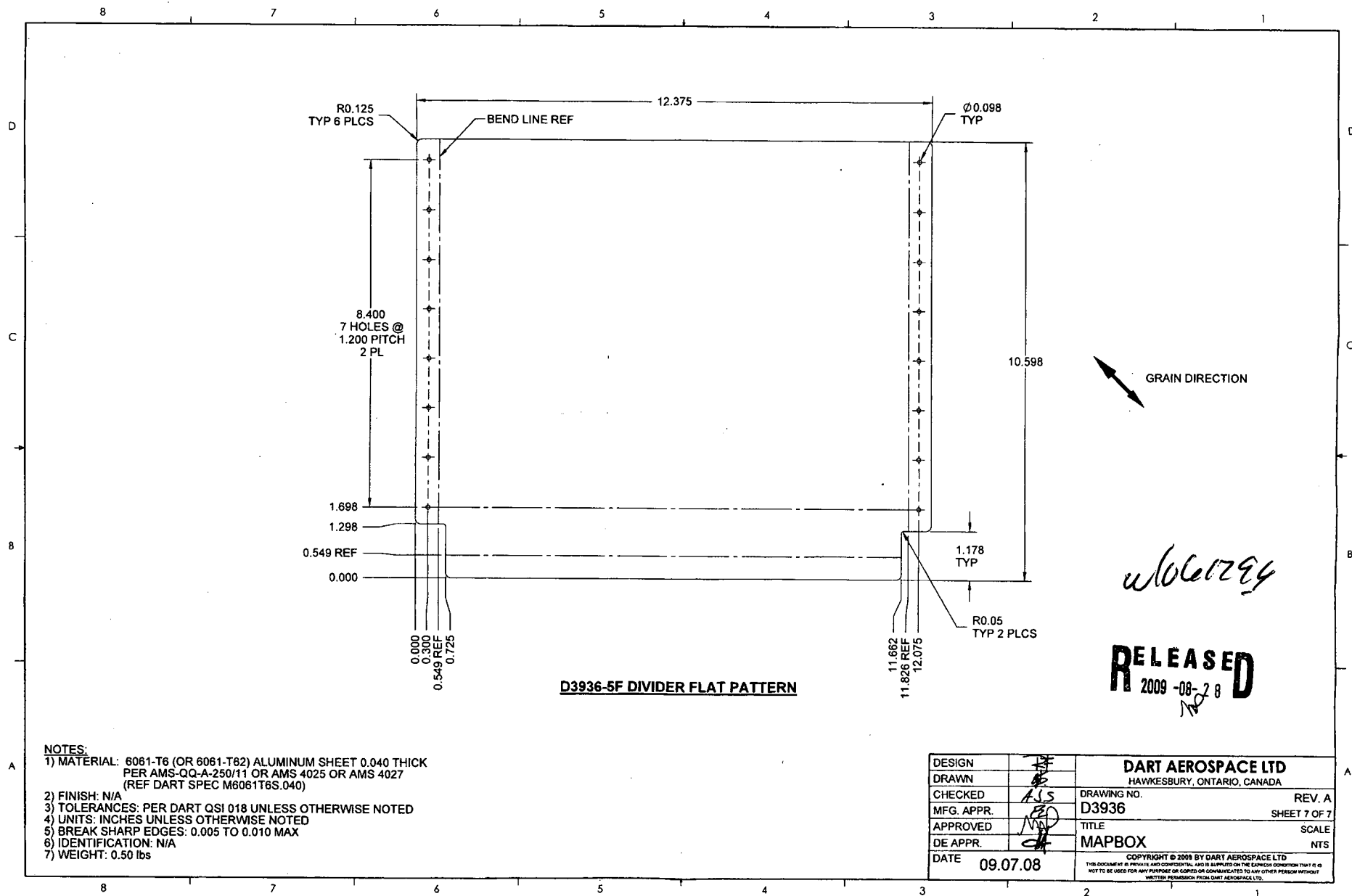
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries